May 19, 2010 9:10:36 AM

Item ID:

D206-628-013

Accept



Setup Start

Stop



Revision ID:

Item Name:

Heli-Access-Step LH

Start Date:

5/19/10

QC:

Start Qty: 5.00

Required Date: 5/21/10 Reg'd Oty: 5.00



Date:

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

SPC (Y/N):

Date:

Run

Start

Stop



Sequence ID/ **Work Center ID** Operation

Description

Set Up/ **Run Hours** **Draw** Number

Draw Rev.

Date:

Plan Accept Code **Qty**

Reject **Oty**

Reject Number Stamp

Insp.

	Draw Nbr	Revision Nbr
	DSI9500	A
l	IIN-D206-628	Rev F

100

DOCUMENT CONTROL

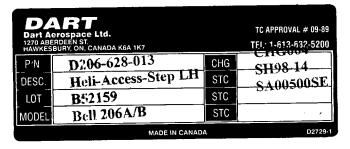
Memo

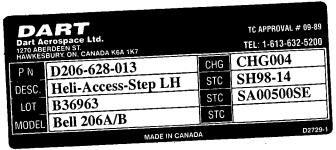
Document Control

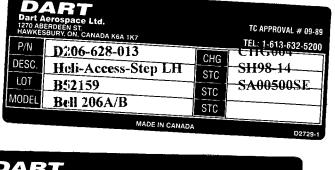
Photocopy blue file and type labels as per PI

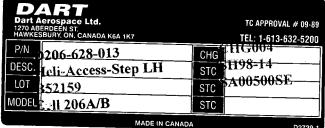


19 for BG 10/06/10 B









Wո	rk	Or	der	ID	58821
* * U	1 17	\mathbf{v}	uvi		

May 19, 2010 9:10:36 AM



Page 2

Item ID:

D206-628-013

Accept



Setup Start

Stop

Stop

Reject

Number



Revision ID:

Item Name:

Heli-Access-Step LH

Start Date:

5/19/10

Start Qty: 5.00

Operation

Description

Pick Kit

Required Date: 5/21/10

Req'd Qty: 5.00



Date:

Cust Item ID:

Customer:

Draw

Number

Reference:

Approvals:

Process Plan:

Date:

Tooling:

SPC (Y/N):

Set Up/

Run Hours

Date:

Draw

Rev.

Plan

Code

Date:

Run Start

Reject

Qty

Accept

Qty



Insp.

Stamp

QC:

Sequence ID/ Work Center ID

110

Packaging Packaging

Memo

0.00

0.00

PULL FROM STOCK: 1 X D206-628-013 B36963 4 X D206-628-013 B52159

CHANGE AS FOLLOWS PER ECN10-530:

REMOVE FROM KITS: 2 X D2731-3 B 2 X D3394-041 B 16 X AN960C416L B

ADD:

2 X D2731-7 B 2 X D3394-043 B 45365 1 X D4064-041 B 3566 7 16 X AN960C416 B TOCOTO 10.5.215/

QC4- 100% Inspect kits for completeness

0.00

Memo

0.00

Dologlio

120

QC

Quality Control

Work Order ID 58821

May 19, 2010 9:10:37 AM

Required Date: 5/21/10



Page 3

Item ID:

D206-628-013

Accept

Setup Start

Stop



Revision ID:

Item Name:

Heli-Access-Step LH

Start Date:

5/19/10

QC:

Start Qty: 5.00

Req'd Qty: 5.00



Cust Item ID:

Customer:

Draw

Number

Reference:

Approvals:

Process Plan: ____

Date:_____

Tooling: Date:

SPC (Y/N):

Date: Date:

Draw

Rev.

Plan

Code

Run Start

Reject

Qty _

Accept

Qty



Stop

Insp.

Stamp

Reject

Number

Sequence ID/ **Work Center ID**

130

Packaging

Packaging

Operation Description

Packaging

Memo REPACKAGE PER PPP USING NEW B/N # CHG 006 Set Up/ **Run Hours**

0.00

0.00

140

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/06/14 AS

Picklist Print

May 19, 2010 9:10:33 AM

Work Order ID: 58821

Parent Item:

D206-628-013

Parent Item Name:

Heli-Access-Step LH

Comments: IPP Rev:E

06-01-06 JLM IPP Rev:D As Per Ecn 766 08-02-05 DD verified by: as per ecn 1118

ncr 09-004 IPP rev F

09.01.09 EC verified by:DD IPP Rev:G

per DSI9500 DD 10.03.01 verified by:JLM



Start Date: 5/19/10

Required Date: 5/21/10

Start Oty: 5.00

Required Qty: 5.00



Purchased

No

No

Each

346.0000

16



Purchased

Location ST346 100993 Loc Qty 346 346 Each

Each

Loc Code

908.0000

x 80



WASHER

Location		Loc Oty	Loc Code
FG		44	
	104925	44	
ST346		864	
	112612	25	
	112794	439	
	112828	400	

Manufactured No





118.0000

Location Loc Qty Loc Code ST469 118 47967 79 52329 39

D2731-3

Mounting Lug

Required Date: 5/21/10

Required Qty: 5.00

May 19, 2010 9:10:34 AM

Work Order ID: 58821

, Parent Item:

D206-628-013

Parent Item Name:

Heli-Access-Step LH

Comments:

IPP Rev:D As Per Ecn 766 06-01-06 JLM

IPP Rev:E as per ecn 1118

IPP rev F ncr 09-004 08-02-05 DD verified by:

09.01.09 EC verified by:DD IPP Rev:G

per DSI9500 DD 10.03.01 verified by:JLM

√D2731-7

Manufactured

No

110

Each 71.0000

Start Date: 5/19/10

Start Qty: 5.00

(A) Mounting Lug

		Location	Loc Qty	Loc Code
		ST470	71	
		41597	23	
		52330	40	
		55773	8	
ired	No		Each	44.0000

D3394-041

Lug Assembly

Manufactured

Manufactured

No

No

Location

ST474

40

Each

Loc Qty 44 4

53446 56528

110

Loc Code

111.0000

Loc Code

D3394-043 Lug Assembly

Location	Loc Qty
ST475	111
44521	5
45365	50
52331	45
55772	11

Page 2

Picklist Print

May 19, 2010 9:10:34 AM

Page 3

Work Order ID: 58821

.Parent Item:

D206-628-013

Parent Item Name:

Heli-Access-Step LH

IPP Rev:D As Per Ecn 766 Comments: IPP Rev:E

as per ecn 1118 IPP rev F

ncr 09-004

08-02-05 DD verified by:

06-01-06 JLM

09.01.09 EC verified by:DD IPP Rev:G

per DSI9500 DD 10.03.01 verified by:JLM

Start Date: 5/19/10

Required Date: 5/21/10

Start Qty: 5.00

Required Qty: 5.00

D4064-041

Manufactured

110

Each

Loc Qty

13

3

10

13.0000

Mounting Lug

W

Location

ST464

56549 56671

Loc Code

BS8980 (4 Pully 10



DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D206-628 REV. F

REF FAA STC: SA00500SE REF TCCA STC: SH98-14 REF EASA STC EASA.IM.R.S.01339

PURPOSE:

UNMODIFIED D206-628-013/-014 STEP INSTALLATIONS AT CHANGE 005 (OR EARLIER) WILL NOT INSTALL AT THE 18.50" HEIGHT REQUIRED FOR COMPATIBILITY WITH APICAL TRI-BAG FLOATS.

CHANGE:

D206-628-013/-014 STEP INSTALLATIONS AT CHANGE 006 (OR LATER) CONTAIN NEW MOUNTING LUGS FOR COMPATIBLITY WITH APICAL FLOATS.

CONTRARY TO INSTALLATION INSTRUCTIONS IIN-D206-628, FOR COMPATIBILITY WITH APICAL TRI-BAG FLOATS, THE D206-628-013/-014 STEP INSTALLATIONS SHOULD BE INSTALLED AT A HEIGHT OF 17.25" PER FIGURE 1 OF THIS SERVICE INSTRUCTION.

WHEN INSTALLING THE MOUNTING LUGS, IT IS ACCEPTABLE TO USE LONGER/SHORTER AN4C BOLTS AS REQUIRED AND/OR INSTALL EXTRA AN960C416/416L WASHERS UNDER THE BOLT HEADS TO ENSURE 1.5 TO 4 THREADS IN SAFETY.

PARTS LIST OF SECTION 5.2 (PG. 12) OF IIN-D206-628-013/-014 REV. F IS AMENDED AS FOLLOWS:

QTY	QTY	QTY	QTY	QTY	QTY	Part Number	Description
-013	-014	-023	-024	-033	-034		
X							206 A/B FLOAT STEP INSTALLATION, LH
	X			i		D206-628-014	206 A/B FLOAT STEP INSTALLATION, RH

WAS:

2	2 _	D2731-3	MOUNTING LUG (EUNOUE
2	2	D2731-7	MOUNTING LUG WALL
2	2	D3394-041	MOUNTING LUG REMUNE
2	2	D3394-043	MOUNTING LUG WE WILL
16	16	AN960C41	

IS:

4	4	D2731-7	MOUNTING LUG Add Z
4	4	D3394-043	MOUNTING LUG 200 2
L	<u> </u>		
1	1	D4064-041	MOUNTING LUG (NEW)
1	1	*D4064-1	LUG
2	2	*MS35489-93	GROMMET ACC
16	16	AN960C416	WASHER 300

^{*} DENOTES THAT PART IS INCLUDED IN ASSEMBLY ABOVE



A	NEW IS	NEW ISSUE			10.01.29
REV.		DESCRIPTION			DATE
DESIGN		9?	DART AEROSPACE USA, INC		
DRAWN		92	PORT HADLOC	K, WA	
CHECKE	D	3	DRAWING NO.		REV. A
MFG. AF	PR.	N/A	DSI 9500		SHEET 1 OF 4
APPRO\	/ED	#	TITLE		SCALE
DE APPR.		#	MOUNTING LUG CHANGE		
DATE 10.01.29			COPYRIGHT © 2010 BY DART AE THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS CUPPL NOT TO BE USED FOR ANY PURPOSE OF COMED OF COMMITTED WHITTEN PRIVASSION FROM OATT AB	ED ON THE EXPR SCATED TO ANY O	ESS CONDITION THAT IT IS THER PERSON WITHOUT



DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D206-628 REV. F.

REF FAA STC: SA00500SE REF TCCA STC: SH98-14 REF EASA STC EASA.IM.R.S.01339

PURPOSE: UNMODIFIED 1990 A CONTROLLING WITH APICA HEIGHT REGISSION AND A CONTROLLING WITH APICA	IS AT CHANGE 005 (OR EARLIER) WILL NOT PID FILE AT THE 18.50" AL TRI-BAG FLOATS.
CHANGE: D206-628-03. A MARCH STANDARDONS AT CHANGE WITH APICAL ACCOUNT.	E 006 (OR LATER) CONTAIN NEW MOUNTING LOST FOR COMPATIBLITY
	206-628, FOR COMPATIBILITY WITH APPOAL TREBARS FLOATS, THE EINSTALLED AT A HEIGHT OF 17.25" PER FIGURE FLOW THIS SERVICE
	EPTABLE TO USE LONGER/SHORTER AN40 BOLT (A3 REQUIRED AND/O THE BOLT HEADS TO ENSURE 1.5 TO 4 THREADS IN SAFETY.
PARTS LIST OF ME (1200 F 1000 R) OF IIN-D206-62	8-013/-014 REV. F IS AMENDED AS FOLLOWS:
QTY QTY QTY C C C C Pert Number C Pert Number C C Pert Number C C C C C C C C C	Description 206 A/B FLOAT STEP INSTALLATION, LM 206 A/B FLOAT STEP INSTALLATION, RM
WAS:	
2 2 2 1.27.31-3 2 2 2 1.27.31-7 2 2 1.3334-041 2 2 1.3334-043 16 16 7.4N960C416L	MOUNTING LUG MOUNTING LUG MOUNTING LUG MOUNTING LUG MOUNTING LUG WASHER
ts:	
4 4 1 2731-7 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1	MOUNTING LUG MOUNTING LUG
1 1 2 D4034-061 5 1 1 3 D4064-1 2 2 3 MS 85489-93	MOUNTING LUG (NEW) LUG GROMMET
16 16 4 A M960C416 /	WASHER
* DENOTES THE STATE OF LICENSTRING ASSEMBLY A	ABOVE

Α	NEW IS	SIJE		CP	10.01.29
REV.			DESCRIPTION	87	DATE
DESIGN		47	DART ALTOS - AC	E US	A, INC
DRAWN		00	BOULHVELOCK		·
CHECKE	0	-13	DRAWING NO.		REV. A
MFG. AP	PR.	NIB	DSI 9500	5	SHEET 1 OF 4
APPROV	/EU	TH.	TITLE		SCALE
DE APPE	₹.	4	MOUNTING LUG CHANGE		NTS
DATE	10.01	.29	COPYRIGHT 9 2016 FT 7 NOT A EN THIS DOCUMENT IS PRIVATE AS PLOWER SHOULT OF SHEETS NOT TO BE USED FOR AND PURPOSE OF OUR TO BE USED FOR AND PURPOSE OF OUR TO BE USED.	OCK! THE EXPRE	SS CONDITION THAT IT IS

Dart Aeros	pace	Ltd
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W/O:			wo	RK ORDER CHA	NGES	····				
DATE	STEP	752				Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
										•
						CR: Yes No DQA: Date:				
	R	· · · · · · · · · · · · · · · · · · ·	lution: Disposition: (/C Closed: Date:			
NCR:	ı	1	WORK ORDE	R NON-CONFOR	RMANCE	(NCR)				
DATE	STEP	Description of NC Section A	Corrective Action Section B				Verifica	ification	Approval	Approval
			Initial Chief Eng	Action Descripti Chief Eng	on	Sign & Date	Section C		Chief Eng	QC Inspector
					:					
										•

NOTE: Date & initial all entries